

Date: Wednesday, 10/11/2006 11:13:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LONG STEP ASSEMBLY HIGH SKID RH
Job Number : 28928	
Estimate Number : 10274	
P.O. Number : N/A	Part Number : D350591312
This Issue : 10/11/2006 S.O. No. : N/A	Drawing Number : D3272 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 28236	Material : N/A
Written By : _____	Due Date : 11/6/2006 Qty: 10 Um: Each
Checked & Approved By : <u>KE 06 10 11</u>	
Comment : Est Rev: A 04.03.22 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

KE 06-10-18 (10)

2.0	D2622120C	Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2622-120 Extrusion 328215

KE 06-11-2

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

KE 06-11-2 10

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

KE 06-11-2 10

3-Deburr

KE 06-11-2 10

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

A 06/11/02 (10)

5.0	D30671	End Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:13:37 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 28928

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3067-1

End Plate 328070

FE 06-11-2

✓
10

6.0

D32191

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support

329235

FE 06-11-2

✓
10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M1983 M19612

3-Grind End Plate flush

FE 06-11-2
FE 06-11-3
FE 06-11-6

✓
10
10
10

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/06/11/07 (13)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/06/11/07 (12)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 11 10 (10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FE 06-11-14

✓
10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Wednesday, 10/11/2006 11:13:37 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 28928

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3065-041 Step Leg Assy 327590

J.E. 06-11-14

✓

10

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3066-1 Spacer 328940

J.E. 06-11-14

✓

10

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet 1101649

J.E. 06-11-14

✓

10

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

J.E. 06-11-14

✓

10

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.E. 06-11-14

✓

10

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate 328270

J.E. 06-11-14

✓

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date:			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:13:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 28928

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M1838*

4-Grind End Plate flush

P.E. 06-11-14

P.E. 06-11-14

P.E. 06-11-15

FF 06-11-15

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/06/11/16 (10)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 11-16 (10)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

Y a.m 06/11/16 X 10

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/11/28

(10X)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

M102635

a.m 06/11/29

(10X)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

DB 06/11/29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 26/11/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:13:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 28928

~~REWORK~~ Number: D350591312

Job Number:



(20)

Seq. #:

Machine Or Operation:

Description :

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 D2230-3 Mounting Lug B28248

27.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 D2618 Bushing B27147 6X B28248 #4X

28.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 D2856-400-720 Abrasion Strip B28208

29.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 D3235-1 Mounting Lug B28272

30.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 1 D3278-041 Support Assembly B28273

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 28928

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 AN3-35A Bolt M101723 -

32.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN4-13A Bolt M102380 -

33.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

* 2 AN5-36A Bolt M19073 -

34.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN960JD10 Washer M100743 -

35.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 16 AN960JD416 Washer M102339 -

36.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN960JD516 Washer M102328 -

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 28928

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 MS21042L3 Nut (or -3) M101917

38.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 MS21042L4 Nut (or -4) M19185

39.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 MS21042L5 Nut (or -5) M102171

PL 6/11/12 (10) ✓

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

LB 06/11/17 (10) ✓

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location: _____

Rev B LB 06/11/30 (10) ✓

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

26/11/30 (10) ✓

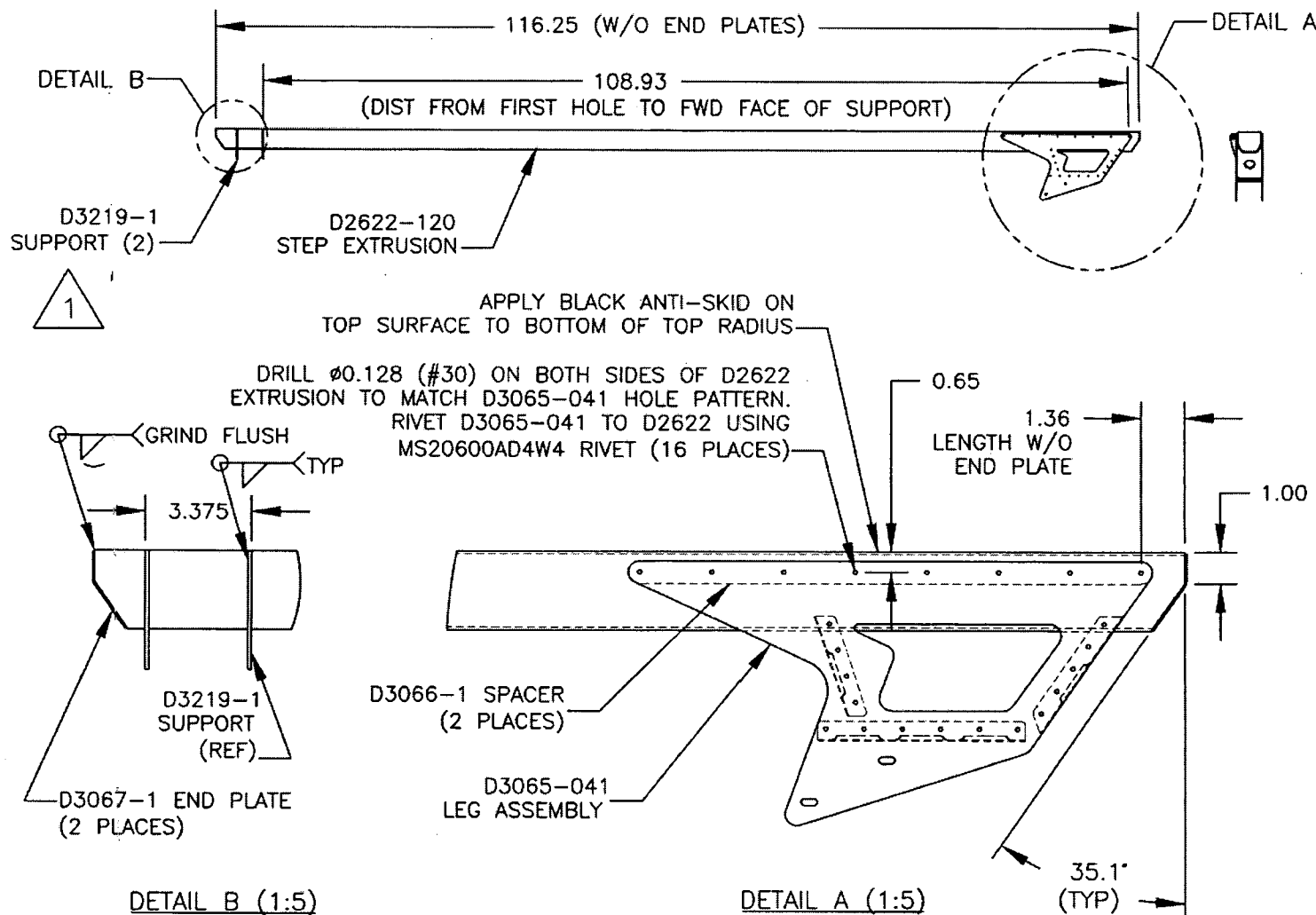
Job Completion



DART



DESIGN	AP	DRAWN BY	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	APPROVED	AP	DRAWING NO. D3272
DATE	04.03.01	TITLE	STEP ASSEMBLY, HI LONG	REV. A SHEET 2 OF 2 SCALE 1:20



RELEASED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28928



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3272	REV. A SHEET 1 OF 2
DATE 04.03.01		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	

RELEASED
04.04.05 *#*

Part No.	Description	QTY -041	QTY -042
D3272-041	Step Assembly, High Long (LH)	X	
D3272-042	Step Assembly, High Long (RH)		X
D2622-120	STEP EXTRUSION	1	1
D3219-1	SUPPORT	2	2
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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NO. 28928

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